

Date: Tuesday, 07/04/2009 10:16:59 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP STRUT
Job Number	: 46944	Part Number	: D2017125
Estimate Number	: 11939	Drawing Number	: D2017 REV <i>OK D E</i>
P.O. Number	:	Project Number	: N/A
This Issue	: 07/04/2009 S.O. No. :	Drawing Revision	: <i>OP D M E</i>
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : SMALL / MED FAB	Due Date	: 22/04/2009 Qty: 8 Um: Each
Previous Run	: 34982		
Written By	:		
Checked & Approved By	: <i>JUD 09.04.07</i>		
Comment	: Est F 02.06.19 Update processes (Ref. ECN 435) KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.7325 f(s)/Unit Total : 13.8600 f(s)

Punch tube type 304-2B, 3/4" Ø. X .049" wall to length per Dwg. D2017 & spec control D2638

Batch No. *M11096*

Debur

M-1 09/04/28 (8X)

50 09/04/27

(8)

2.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

50 09/04/28 (X8)

3.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

15:40

OVEN TEMPERATURE:

400°

FINISH TIME:

16:10

CMO/PL

09/04/28 (X8)

4.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

FL 09/04/29 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/04/2009 10:16:59 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP STRUT

Job Number: 46944

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 258

09/04/29 (KS)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/30
MF

Job Completion



MF 09-04-29

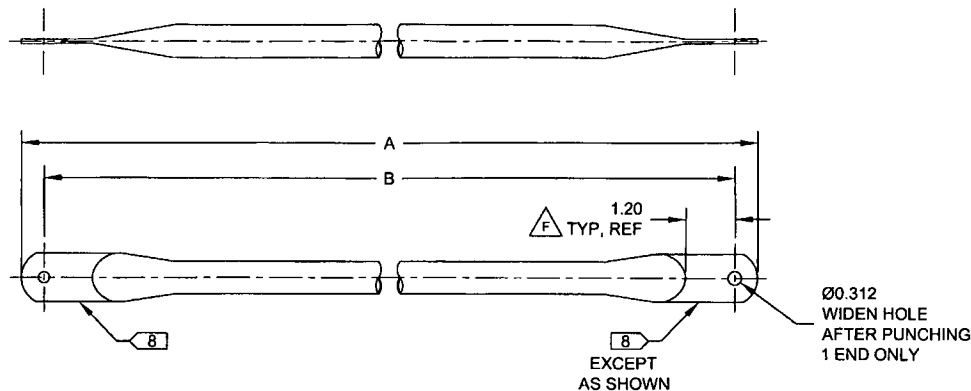
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2017-XXX STEP STRUT

PART NUMBER	A	B
D2017-101	17.73	16.93
D2017-103	18.74	17.94
D2017-113	20.50	19.70

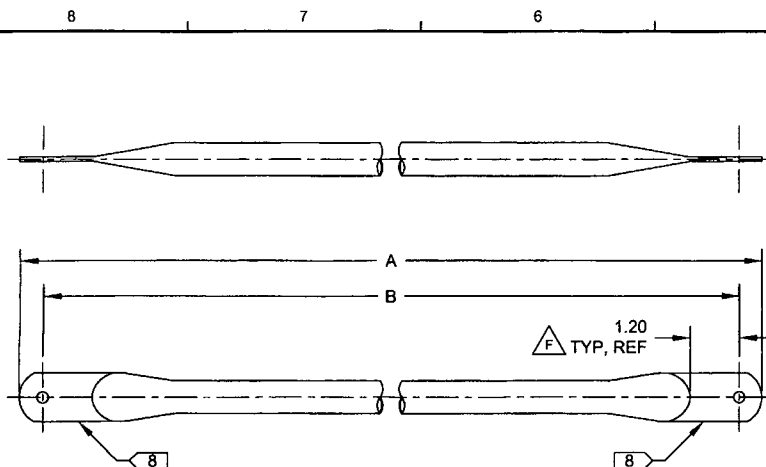
RELEASED
09/04/16

REFERENCE ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, Ø0.750 x 0.049 WALL
REF. DART SPEC M304TR0.750W.049
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2017-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) PUNCH ENDS PER SPEC CONTROL DRAWING D2638.

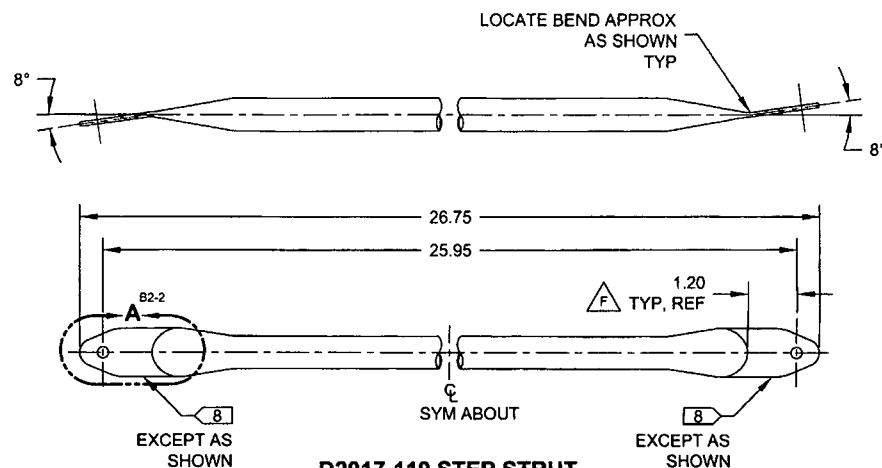
REV.	DESCRIPTION	BY	DATE
F	DRAWING TRANSFERRED TO "B" FORMAT AND TO CURRENT STANDARDS. REDRAWN FOR CLARITY 1.20 REF DIM ADDED. SEE PAR 09-002 FOR DETAILS.	AJS	09.03.06
E	ENDS PUNCHED PER SPEC CTRL; -119 CHANGE (TSR A897) ADD FINISH (INCOPORATE E1)	CP	02.03.22
D	ADDED PARTS	BW	96.03.28
C	ADDED PARTS	BW	95.01.26
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2017	REV. F
MFG. APPR.		TITLE	SCALE
APPROVED		STEP STRUTS	NTS
DE APPR.		COPYRIGHT © 1995 BY DART AEROSPACE LTD	
DATE	09.03.06	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS TO BE USED ONLY FOR THE PURPOSES FOR WHICH IT IS ISSUED. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.	



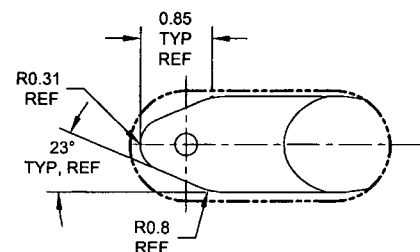
D2017-XXX STEP STRUT

PART NUMBER	A	B
D2017-105	14.95	14.15
D2017-107	15.61	14.81
D2017-109	13.93	13.13
D2017-111	15.30	14.50
D2017-115	12.42	11.62
D2017-117	13.86	13.06
D2017-121	12.30	11.50
D2017-123	12.92	12.12
D2017-125	19.55	18.75
D2017-127	20.30	19.50
D2017-129	31.43	30.63
D2017-131	19.68	18.88
D2017-201	21.31	20.51
D2017-203	16.39	15.59
D2017-205	16.53	15.73
D2017-207	13.85	13.05
D2017-209	15.64	15.33
D2017-211	15.67	14.87
D2017-213	15.82	15.02
D2017-215	16.47	15.67
D2017-217	16.70	15.90
D2017-219	13.65	12.85
D2017-221	13.58	12.78
D2017-223	12.95	12.15
D2017-225	13.99	13.19
D2017-227	30.67	29.87
D2017-133	30.66	29.86

REFERENCE ONLY
46944



D2017-119 STEP STRUT
(SHOWN PRIOR TO BENDING)



DETAIL A D4-2
TRIM AFTER PUNCHING PER DT8360
SCALE 2X

RELEASED
09/04/16

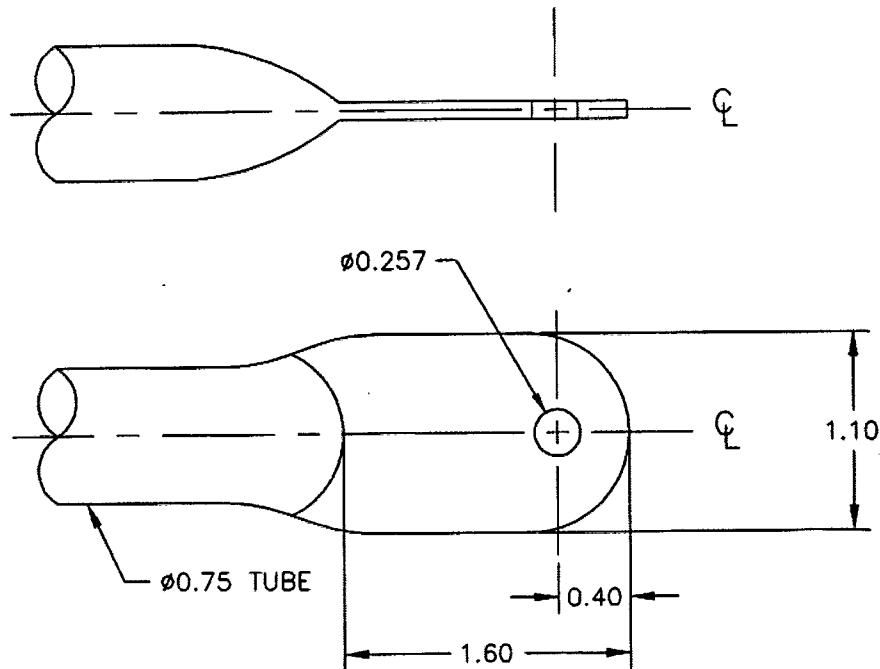
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2017	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP STRUTS	NTS
DATE	09.03.06	COPYRIGHT © 1995 BY DART AEROSPACE LTD	



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED mg	APPROVED [Signature]	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
46/07/05 KE

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8117



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NO. 46944